

Work Order ID 72653

Thursday, August 04, 2011 7:43:08 AM

Page 1

Item ID: D3999-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Baffle Assembly, Aft

Start Date: 8/3/2011 Start Qty: 4.00

Required Date: 8/5/2011 Req'd Qty: 4.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3999

A

100

0.00



Waterjet

FLOW CNC Waterjet

661. 663

Memo

1-Cut as per Dwg D3999-1

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

0.00

B11-8-16

(6)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00



B11-8-16




Work Order ID 72653

Page 2

Thursday, August 04, 2011 7:43:08 AM

Item ID: D3999-041 Accept  Setup Start 
Revision ID: Stop 
Item Name: Baffle Assembly, Aft
Start Date: 8/3/2011 Start Qty: 4.00  Cust Item ID:
Required Date: 8/5/2011 Req'd Qty: 4.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--|--|----------------------|---------|------------|--------------|---------------|---------------|------------------|----------------|
| 120  QC Quality Control | QC8- Inspect parts - second check Memo | 0.00 0.00 | | Sulosic | | (fb) | | | |
| 130  Brake NC Brake NC | Bend as per dwg Memo Bend D3999-1 as per Dwg | 0.00 0.00 | | Sb 1165124 | | (6) | | | |
| 180  Small Fab Small Fab | Memo Assemble as per dwg | 0.00 0.00 | | | | EP 11/08/26 | (6) | | |

Picklist Print

Thursday, August 04, 2011 7:43:06 AM

Page 1

Work Order ID: 72653

Parent Item: D3999-041

Parent Item Name: Baffle Assembly, Aft




Start Date: 8/3/2011

Required Date: 8/5/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP rev A 09.12.16 new issue Prelim EC verified by:DD IPP rev B
10.05.10 ecn 10-562 EC verified by:DD

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|-----------------|-------------|--------------|---------------|----------------|--------|
| D3999-5  Angle | | Manufactured | No | | | 180 | Each | 12.0000 | 2 | 8 | | | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | ST104 | | 12 | | | | | | | |
| | | | | 71295 | | 12 | | | | | | | |
| M6061T6S.063  6061-T6 .063 Sheet | | Purchased | No | | | 100 | sf | 147.2256 | 2.27 | 9.557895 | | | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | MAT021 | | 147.2255684 | | | | | | | |
| | | | | 116308 | | 26.9755684 | | | | | | | |
| | | | | 117285 | | 120.25 | | | | | | | |
| MS20470AD4-4  Rivet, Universal Head | | Purchased | No | | | 180 | Each | 976.0000 | 12 | 48 | | | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | ST139 | | 434 | | | | | | | |
| | | | | 117423 | | 434 | | | | | | | |
| | | | | ST319 | | 542 | | | | | | | |
| | | | | 116188 | | 476 | | | | | | | |
| | | | | 116391 | | 66 | | | | | | | |

Handwritten: 8/11/08/26
B 72654
(94) (72X)

Handwritten: B11-8-16 15,
(6)

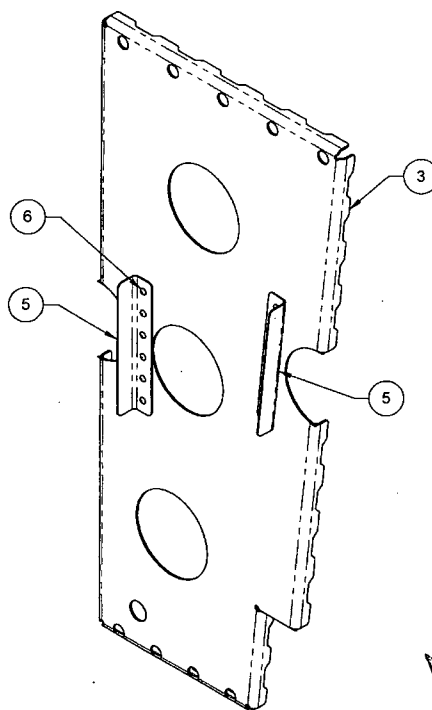
Handwritten: 8/11/08/26
7/11/8/14
(72X)

| | | | |
|-------------------------------------|--|---------------------|---------|
| DART AEROSPACE LTD | | Work Order: | 72683 |
| Description: Baffle | | Part Number: | D3999-1 |
| Inspection Dwg: D3999 Rev: A | | Page 1 of 2 | |

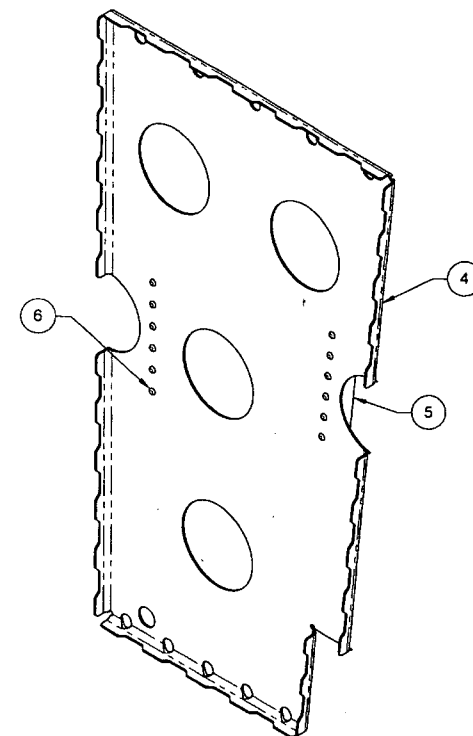
FIRST ARTICLE INSPECTION CHECKLIST

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| Ø0.129 | +0.005/-0.001 | .130 | ✓ | | V B02 | |
| Ø0.50 | +0.006/-0.001 | .500 | ✓ | | V | |
| Ø3.35 | +0.012/-0.001 | 3.349 | ✓ | | V | |
| 0.71 | +/-0.030 | .711 | ✓ | | V | |
| 1.01 | +/-0.030 | 1.013 | ✓ | | V | |
| 5.93 | +/-0.030 | 5.932 | ✓ | | V | |
| 10.77 | +/-0.030 | 10.771 | L | | PROWJ02 | |
| 11.44 | +/-0.030 | 11.444 | ✓ | | P | |
| 0.900 | +/-0.010 | .904 | ✓ | | V | |
| 13.02 | +/-0.030 | 13.02 | ✓ | | T B01 | |
| 14.59 | +/-0.030 | 14.59 | ✓ | | T | |
| 20.10 | +/-0.030 | 20.10 | ✓ | | T | |
| 24.02 | +/-0.030 | 24.02 | ✓ | | T | |
| 25.30 | +/-0.030 | 25.30 | | | T | |
| 25.36 | +/-0.030 | 25.36 | ✓ | | T | |
| 26.07 | +/-0.030 | 26.07 | ✓ | | T | |
| 1.52 | +/-0.030 | 1.529 | ✓ | | V | |
| 2.43 | +/-0.030 | 2.443 | ✓ | | V | |
| 3.27 | +/-0.030 | 3.273 | ✓ | | V | |
| 4.00 | +/-0.030 | 4.001 | ✓ | | V | |
| 5.02 | +/-0.030 | 5.027 | ✓ | | V | |
| 6.77 | +/-0.030 | 6.784 | ✓ | | V | |
| 7.58 | +/-0.030 | 7.583 | ✓ | | V | |
| 0.71 | +/-0.030 | .712 | ✓ | | V | |
| 8.27 | +/-0.030 | 8.274 | ✓ | | V | |
| 10.73 | +/-0.030 | 10.735 | ✓ | | P | |
| 21.10 | +/-0.030 | 21.10 | ✓ | | T | |
| 0.71 | +/-0.030 | .709 | ✓ | | V | |
| 1.58 | +/-0.030 | 1.597 | ✓ | | V | |
| 2.66 | +/-0.030 | 2.662 | ✓ | | V | |
| 3.94 | +/-0.030 | 3.949 | ✓ | | V | |
| 4.72 | +/-0.030 | 4.731 | ✓ | | V | |
| 5.43 | +/-0.030 | 5.444 | ✓ | | V | |
| 6.30 | +/-0.030 | 6.325 | ✓ | | V | |
| 8.66 | +/-0.030 | 8.684 | ✓ | | P | |
| 11.02 | +/-0.030 | 11.049 | ✓ | | T | |
| 11.65 | +/-0.030 | 11.653 | ✓ | | T | |

| ITEM NO. | QTY. -041 | QTY. -043 | PART NUMBER | DESCRIPTION | JOHN CAMERON AVIATION PART NUMBER |
|----------|--------------|--------------|-------------|----------------------|--------------------------------------|
| 1 | X | | D3999-041 | BAFFLE ASSEMBLY, AFT | JCA-M47-1-02 |
| 2 | | X | D3999-043 | BAFFLE ASSEMBLY, FWD | JCA-M47-1-03 |
| 3 | 1 | | D3999-1 | BAFFLE | |
| 4 | | 1 | D3999-3 | BAFFLE | |
| 5 | 2 | 2 | D3999-5 | ANGLE | |
| 6 | 12 | 12 | MS20470AD4 | RIVET | |



D3999-041 BAFFLE ASSEMBLY, AFT



D3999-043 BAFFLE ASSEMBLY, FWD

RELEASED
2010-05-05

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3999-041/-043" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT (-041): 1.51 lbs
- 8) WEIGHT (-043): 1.84 lbs

| | | | |
|------------|-------------|----|----------|
| A | NEW ISSUE | | 10.02.05 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | | | |
| DRAWN | | | |
| CHECKED | | | |
| MFG. APPR. | | | |
| APPROVED | | | |
| DE APPR. | | | |
| DATE | 10.02.05 | | |

| | | |
|--|---------------|--------|
| DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | | REV. A |
| DRAWING NO. D3999 | SHEET 1 OF 12 | |
| TITLE BAFFLE | SCALE NTS | |
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DART AEROSPACE
PART NUMBER
D3999-1

JOHN CAMERON AVIATION
PART NUMBER
REF JCA-M47-1-02

0.61
REF

R0.19
TYP

25.09

11.44

10.58

4.50

7.38

9.38

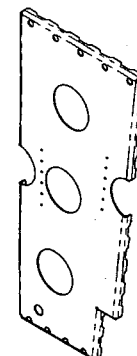
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D3999-1 BAFFLE

72653

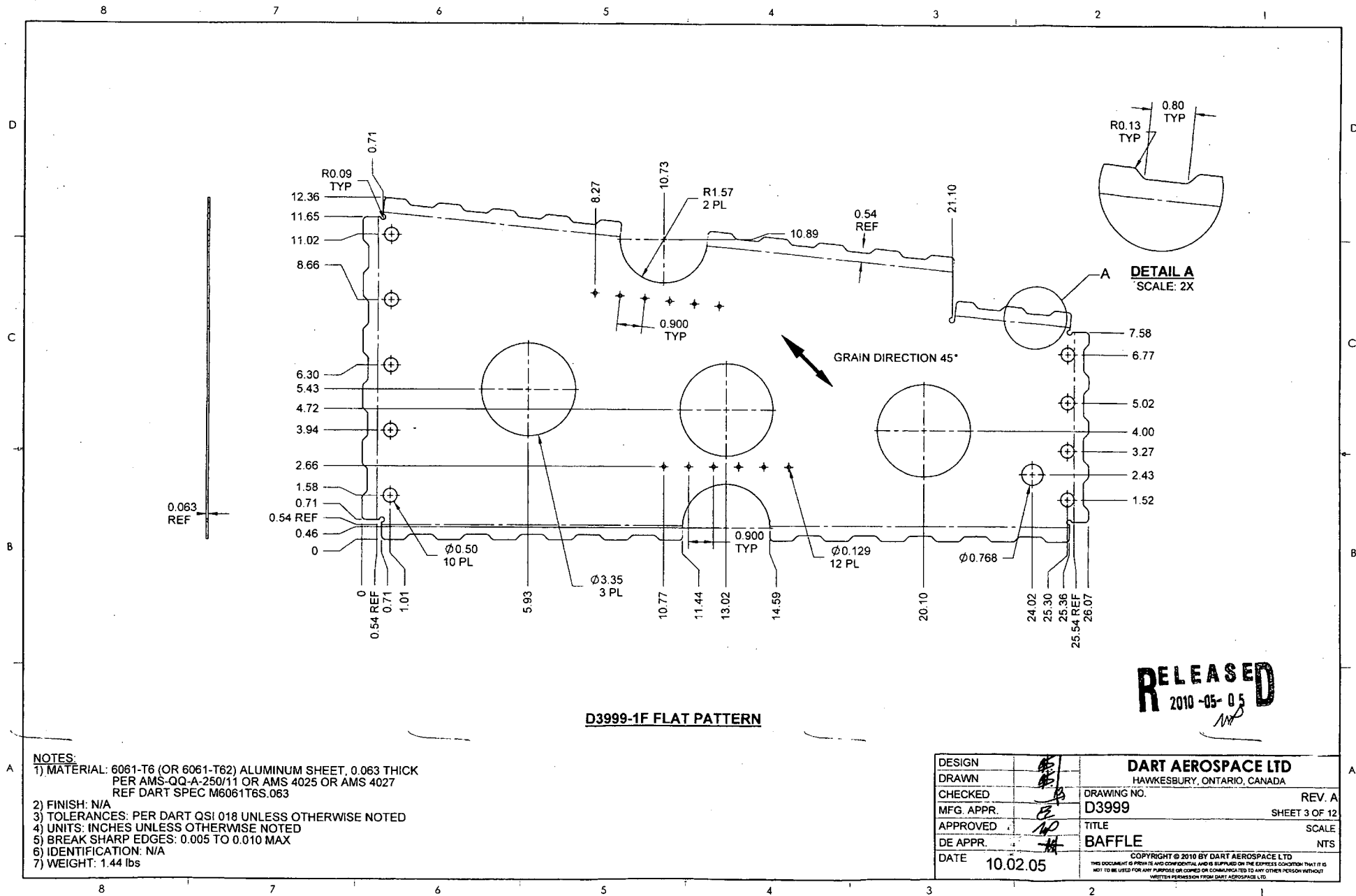
NOTES:

- 1) MATERIAL: MADE FROM D3999-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.44 lbs



RELEASED
2010-05-05
MD

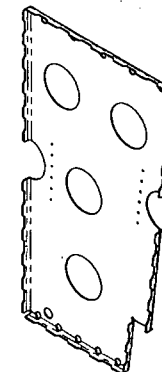
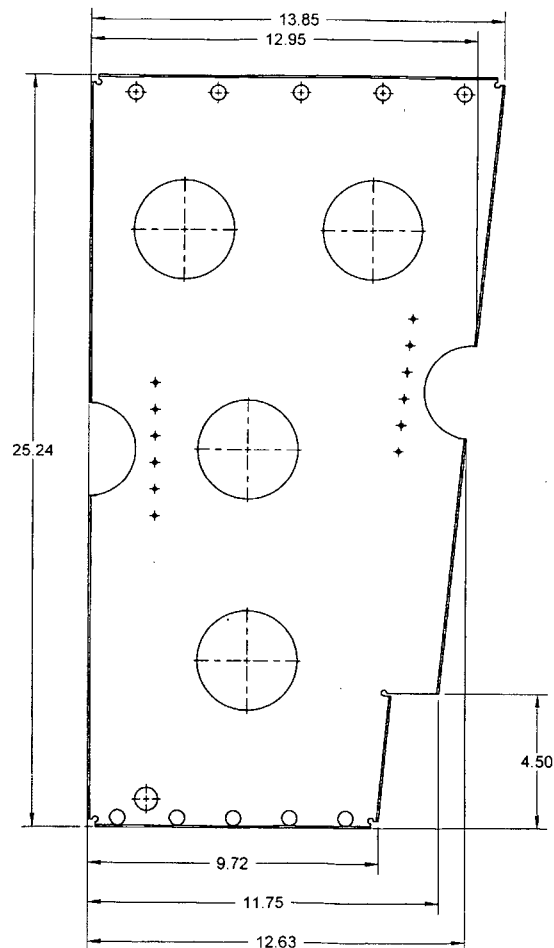
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|------------|----------|---|---------------|
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| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. D3999 | REV. A |
| MFG. APPR. | | TITLE BAFFLE | SHEET 2 OF 12 |
| APPROVED | | | SCALE |
| DE APPR. | | | NTS |
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| DART AEROSPACE PART NUMBER | JOHN CAMERON AVIATION PART NUMBER |
|-------------------------------|--------------------------------------|
| D3999-3 | REF JCA-M47-1-03 |

R0.19
TYP

0.61
TYP



D3999-3 BAFFLE

NOTES:

- 1) MATERIAL: MADE FROM D3999-3F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.77 lbs

RELEASED
2010-05-03
JW

| | | | |
|------------|----------|---|---------------|
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| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. D3999 | REV. A |
| MFG. APPR. | | TITLE BAFFLE | SHEET 4 OF 12 |
| APPROVED | | | SCALE |
| DE APPR. | | | NTS |
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